

Work Order ID 81962-2

March-21-12 1:43:43 PM

81962

Page 1

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 21/03/2012 Start Qty: 200.00

Required Date: 04/04/2012 Req'd Qty: 200.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

QC:

Date: 12/03/21

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut D2230 extrusion to 0.82"

Batch:

0.00

Cut @ meter

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

0.00

issue P/O to meter

machine as per drawing D2230 REV.G

PO 10535

12/03/22

Work Order ID 81962

March-21-12 1:43:43 PM

81962

Page 2

Item ID: D2230-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 21/03/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *no'd*
120
QC
Quality Control

~~QC2- Inspect parts off machine FAI/FAIB~~

0.00

Memo

0.00

*no'd + inspect
attached c-ffc to w/d*

QC Inspect parts - second check

0.00

Memo

0.00

130
130
QC
Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

150
150
HandFinish
Hand Finishing

u/ SP

12-5-4

*enter
(H3C)
asp 019*

*(130)
110*

11/25-7

Work Order ID 81962

March-21-12 1:43:43 PM

81962

Page 3

Item ID: D2230-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 21/03/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

~~130X~~
110

~~Ø~~

M/f
12/05/07

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11-20

OVEN TEMPERATURE: 320 °F

FINISH TIME: 11-50

~~130X~~
110

~~Ø~~

M/f
12/05/07

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

110

12-5-7

M121134

Work Order ID 81962

March-21-12 1:43:43 PM

81962

Page 4

Item ID: D2230-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 21/03/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location **57480** 0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

Quality Control

CR/5/8 *(110)*

12/5/12

ME 12-05-08

Picklist Print

March-21-12 1:43:47 PM

Page 1

Work Order ID: 81962

Parent Item: D2230-3

Parent Item Name: Lug

81962
D2230-3

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 200.00

Required Qty: 200.00

Comments:

IPP D00.05.18 Added inspection level 8, and removed P/O for powder coat EC
25 JLM VERIFIED BY:EC
IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		200			
D2230-3P									**				
LUG													
D2423		Manufactured	No			100	f	307.3690	0.0683	14.37895			
D2423									**				
Lug Extrusion													

Spd 5-4

CL 12/03/23

Location

Loc Qty

Loc Code

MAT006

307.369

43722

161.5

45800

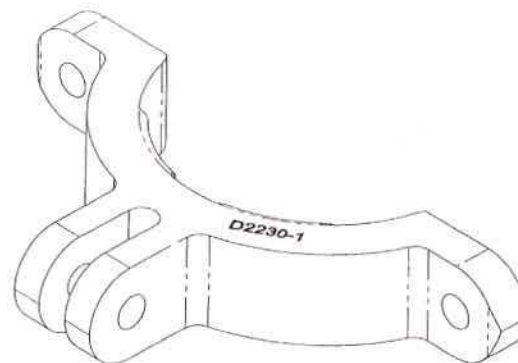
1

68331

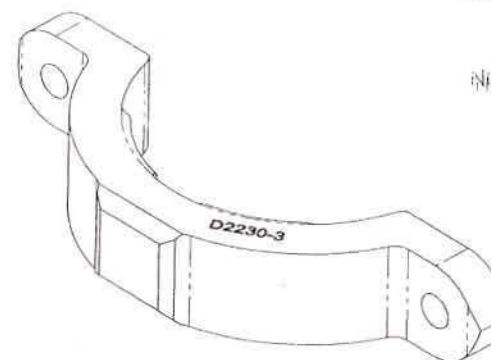
144.869

14.38

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. 81962 MJS
12/03/21



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/01/16

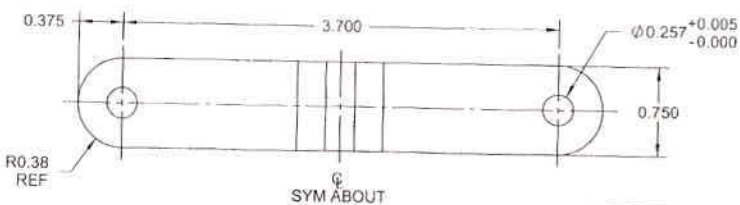
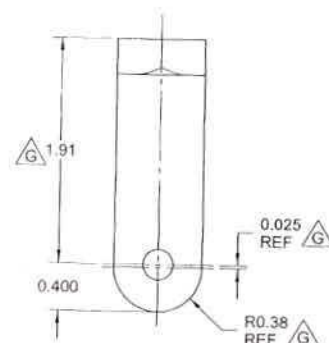
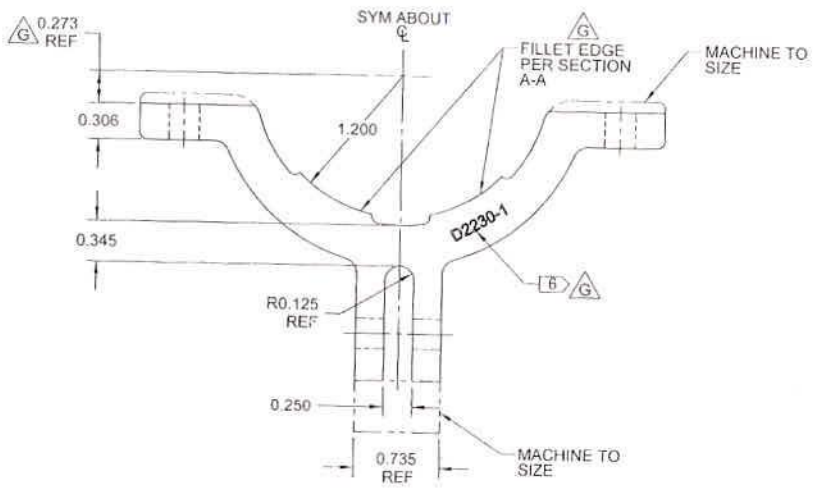
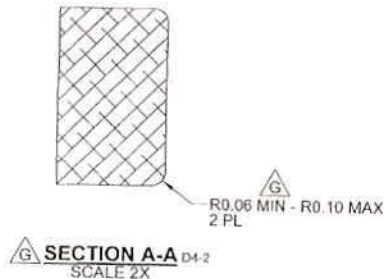
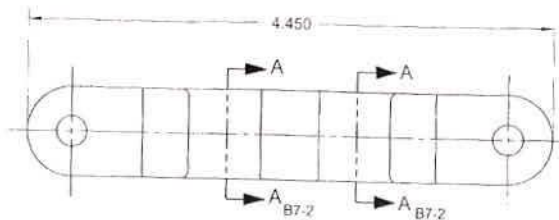


NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4 3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN, R1 200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

81962

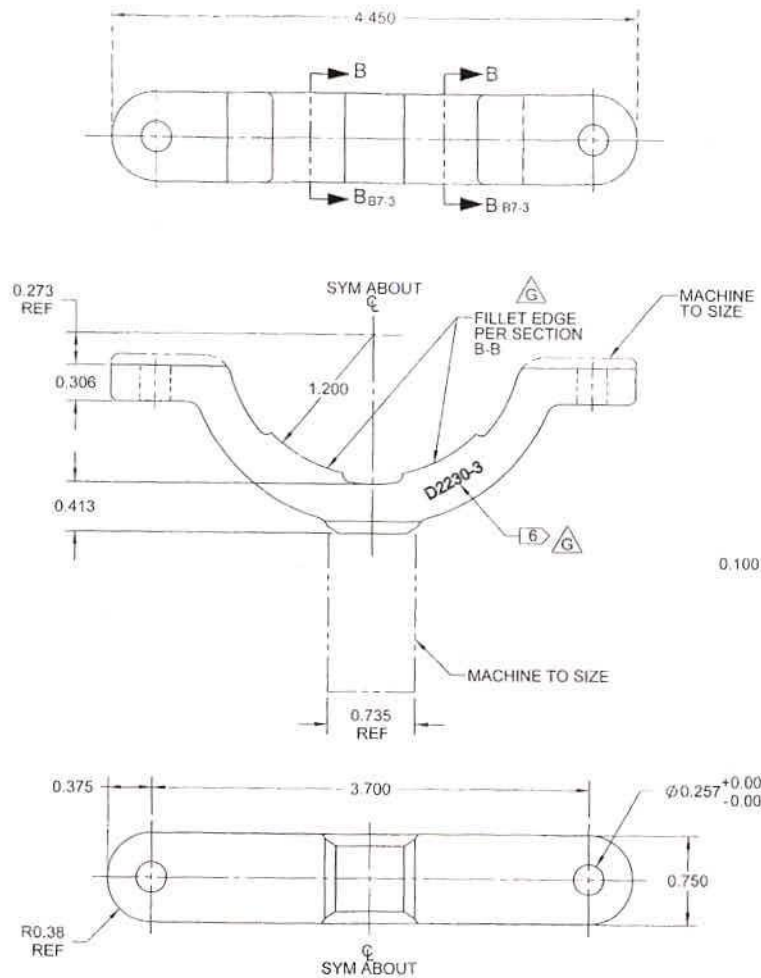
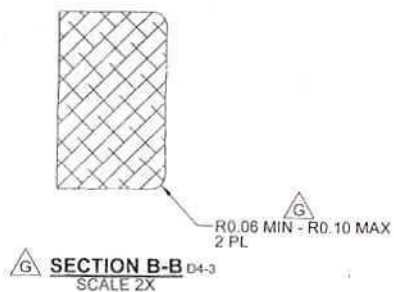


RELEASED
07/06/25

D2230-1 MOUNTING LUG

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

81962



D2230-3 MOUNTING LUG

RELEASED
09/06/2014

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18550**
Date: May 03, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16535	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: May 03, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3235-1 Mounting Lug as per DWG: D3235 REV:A B81970	Each	100		
D2230-3 Mounting Lug as per DWG: D2230 REV:G B81962	Each	200	130	70
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
130	D2230-3P	Lug	16535

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, May 3, 2012



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16535

Purchase Order Date 3/22/2012

PO Print Date 3/22/2012

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3235-1P	lug	4/4/2012 Yes	✓ 100.00 Each	Dart Truck	\$15.0500	\$1,505.00
Special Inst:			AS PER DWG: D3235 REV: A B81970				
2	D2230-3P	LUG	4/4/2012 Yes	200.00 Each	Dart Truck	\$13.0000	\$2,600.00
Special Inst:			AS PER DWG: D2230 REV: G B81962				

PO Total:

\$4,225.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/22/2012